

Date: Wednesday, 1/23/2008 11:37:07 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP EXTRUSION		
Job Number	: 36923					
Estimate Number	: 10058					
P.O. Number	:		Part Number	:	D2622120C	
This Issue	: 1/23/2008	S.O. No. :	Drawing Number	:	D2622 REV C1	
Prsht Rev.	: NC		Project Number	:	N/A	
First Issue	: / /	Type : PURCHASED PARTS	Drawing Revision	:	C1	
Previous Run	: 35618		Material	:		
Written By	:	<i>1080123</i>	Due Date	: 2/10/2008	Qty:	120 Um: Each
Checked & Approved By	:					
Comment	: Est. A: 02.11.12 New Issue KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		<i>1080123</i>
		<i>120</i>
	Comment: PURCHASING Issue P/O: <i>5521</i>	
	a) Extrude as per Dwg D2622 Rev. C	
	b) Material: 6061-T6 (QQ-A-200/8)	
	c) Minimum yield tensile strength = 35 ksi	
	d) Minimum ultimate tensile strength = 38 ksi	
	e) Minimum elongation = 8%	
	f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A	
	h) To be packed per DSK 066	
	i) Pull test to ASTM standard B221 required.	
	j) Material certification is required	
2.0	D2622120CP	Extrusion
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 120.0000 Each(s)	
	Extrusion	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached	
		<i>130</i>
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK Inspect dimension per Dwg D2622 Check Pull test per Dwg D2622 for compliance page attached Check hardness with Webster tester	
		<i>counts</i>
		<i>1080123 XBD</i>

W/I:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2622-120C PAR #: N/A Fault Category: Prod / Packaging NCR: Yes No DQA: Date: 08/02/15
 QA: N/C Closed: Date: 08/02/19

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/11	#	3# steps D2622-120c found with defects 1- looks like it has two holes	08/04/12	Prints are acceptable on Surface cont'd * SCRAP and DESTROY all	N/A J	08/02/14	08/04/12	08/02/14
		21- with large dent on side 1- with that has a twist in it.	08/04/12	Turned part Cut X3	N/A J	08/02/14	08/04/12	08/02/11
				use for short steps				

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

in the Back by Reium Dart

08/08/14 Form

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(130)

Comment: FINAL INSPECTION/W/O RELEASE

08/08/15

min 2008/2/14

(130)

Job Completion



V

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

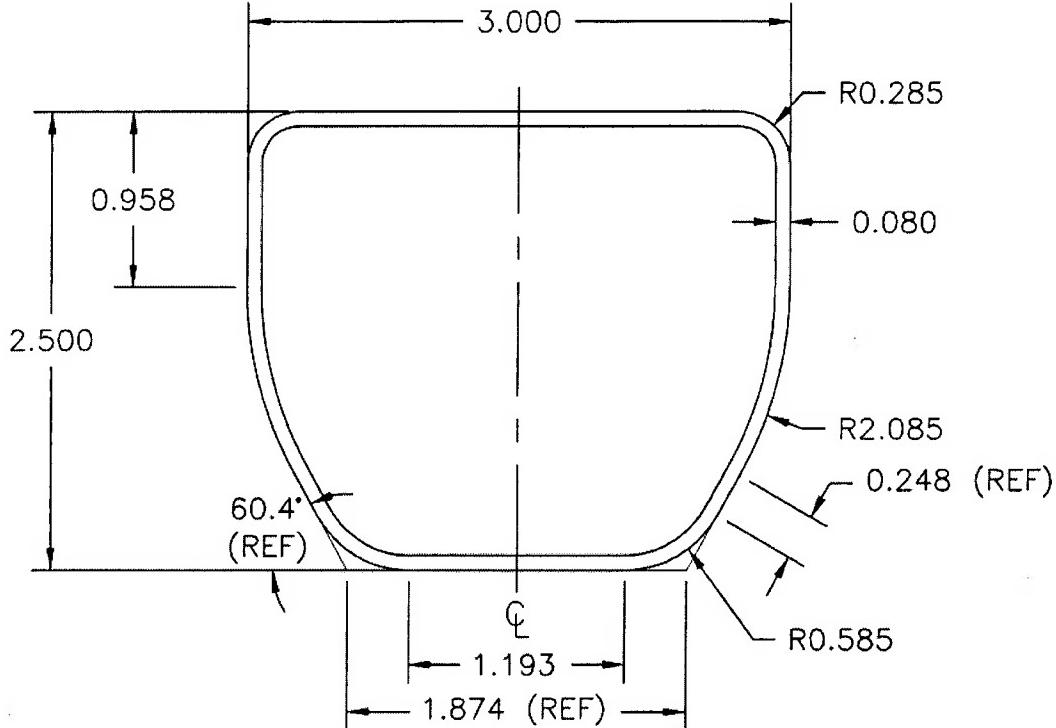
NOTE: Date & initial all entries



COPIED
02.09.11

DESIGN	KE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>✓</i>	APPROVED	DRAWING NO.	REV. C
			D2622	SHEET 1 OF 1
DATE	02.09.11		TITLE	SCALE
			STEP EXTRUSION	1:1
A	96.11.29	NEW ISSUE		
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI		
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.		
CI	<i>✓ CP</i> 02.10.04	ADD 'REV. A' TO DIE NUMBER.		

RELEASED
02.09.11 *✓*



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 Rev. A *✓*
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
 MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *36923*



CERTIFICATE OF COMPLIANCE

BON L CANADA INC

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Order Date	Customer	Sales Order	Page
02/04/08	172753	21963	1
Print Date	Printed By	Date	Date
5521	00371407	21963010	2/04/08

Shipped To:	Ship To:	Shipped:
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	160724

Item No.	Part No.	Item Description	Cost Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622
Gross Weight	562	KGS	
Net Wt.	542	KG	130 PC 396 M 2 PKG
Specification:			Std. Datas
AMS-QQ-A-200/8 & ASTM B221-06			

Mechanical Tests:

Test	Tensile	Yield	%Elongation	Conductivity	Bend/ Drift	HREW
No.	MPA / KSI	MPA / KSI				
1	306.2 / 44.4	271.1 / 39.3	10.1	.0	93	

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.61	.21	.21	.08	.82	.06	.000	.04	.000	.000	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada

